

Date: Monday, 1/14/2008 2:32:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPRING
Job Number	: 36725		
Estimate Number	: 10862		
P.O. Number	: <i>N/A</i>	Part Number	: D31131
This Issue	: 1/14/2008	S.O. No.	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Drawing Number	: D3113 REV B
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 27366	Drawing Revision	: B
		Material	: <i>N/A</i>
		Due Date	: 1/31/2008
Written By	: <i>[Signature]</i>	Qty:	20
Checked & Approved By	: <i>[Signature]</i> 08 01 15	Um:	Each
Comment	: Est. A 02.05.16 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0525 sf(s)/Unit Total : 1.0500 sf(s)

304/316 .063 Sheet

BATCH: *10663* *IB 8-1-16*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: *B* *IB 8-1-16*Prog Rev: *B*2-Deburr if necessary *IB 8-1-16*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-1-16*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] *08/01/16 +25*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

all Done Step #22.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with fine point marker per dwg D3113 and Stock

Location: bb

86.116 SD (25x)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

D080117

Job Completion



u 86.116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

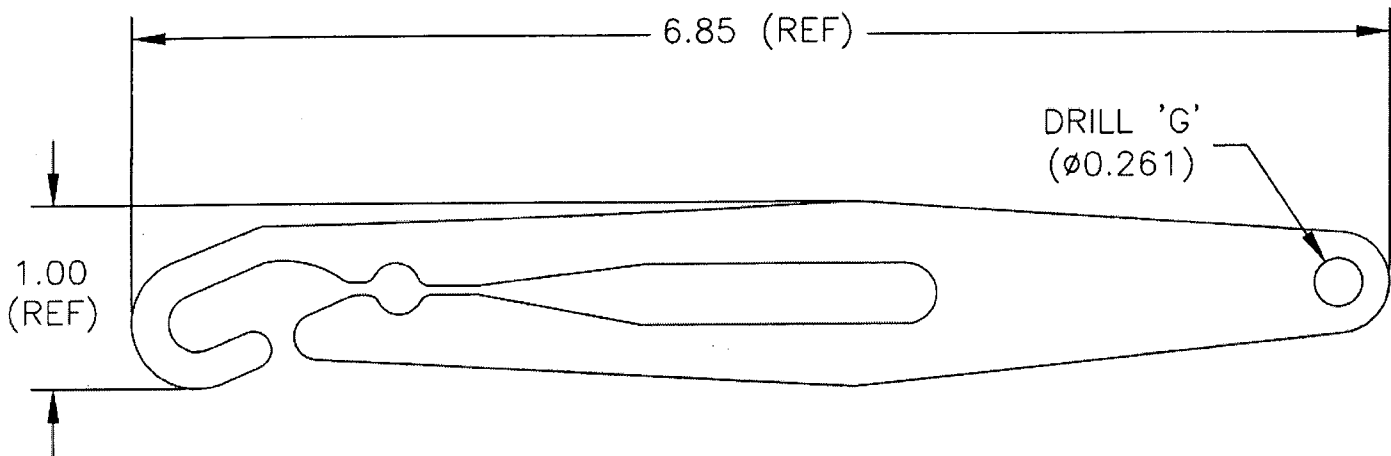
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN A	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3113	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE SPRING	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; ADDED ANNEALED	

RELEASED
04.11.23



D3113-1 SPRING

NOTES:

- 1) MACHINE PER DWG FILE "D3113-B1.DWG"
- 2) MATERIAL: ANNEALED 16 GAUGE (0.063" REF) AISI 304/316 SS SHEET PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36725

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